Work Order ID 97891

March-01-13 10:40:59 AM

97891

Item ID: D5957
Revision ID:
Item Name: Saddle, 205

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

Start Date: 3/01/13 **Start Qty:** 4.00 *4*
Required Date: 3/15/13 **Req'd Qty:** 4.00 *4*
Reference:

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** MLJ **Date:** 13-03-01 **Tooling:** **Date:**
QC: **Date:** **SPC (Y/N):** **Date:**

SCRAP

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr: D5957	Revision Nbr: Rev B								
100	HAAS CNC VERTICAL MACHINING #1	0.00							
100									
HAAS 1	**Memo**	0.00							
HAAS CNC vertical machine #1	1-Machine as per folio D5957,Ensure Batch Number is entered2-Machine Keyway3-Deburr & Tumble		FK 13/03/16			4	Ø		
110	QC1- Inspect dimensions to dimension sheet	0.00							
110									
QC	**Memo**	0.00	FK 13/03/16			4	Ø		
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	**Memo**	0.00	[redacted]			4			
Quality Control									

DQA: [illegible] Date: 13/04/08

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: [illegible] Date: 4/2/13

Work Order: 97891

Part No. D5957

NCR No. 13.2438

DISPOSITION

Rework	
Scrap	X
Use-as-is	
Work Order Update	

AGAINST DEPARTMENT/PROCESS

Skid-tube		Crosstube		Water Jet	Engineering
Machining	✓	Small Fab		Prod. Eng. Coor.	Quality
Thermoforming		Finishing		Rec/Store/Packaging	Other
Large Fab		Composite		Supplier	

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data		13/3/19	100	4	Spot face ~~###~~ for P/N / b/N too deep.	[illegible] 13.03.19	SCRAP CP 13/3/19	13/03/26 F#	DAS 16 13/3/26	DAS 16 13/3/26
Equip/Tooling							inform engineer of issue.			
Operator	X									
Material										
Setup										
Other										
Process										
Supplier										
Training										
Unapproved										

241.52 [illegible] 9/06 OB

FAULT CATEGORY

Landing Gear

- Bending
- Centre Not Concentric to O/S
- Cracks
- Crushed/Crimped
- Cuffs
- Heat Treat
- Inspection Strip in Tube
- Ripples in Bend
- Torque Waves in Extrusion
- Turning Sequence
- Wave/Twist in Tube

General

- Bend
- BOM/Route
- Broken/Damaged
- Burrs
- Contamination
- Countersink
- Cut Too Short
- Drill Holes
- Drawing
- Finish
- Folio
- Grain
- Hardware
- Inspection Incomplete
- Instructions Incomplete/Unclear
- Maintenance
- Mislabeled
- Misread
- Offset
- Out of Calibration
- Out of Sequence
- Outside Dimensions
- Ovalized
- Over/Under tolerance
- Part Incorrect
- Part Lost/Missing
- Part Moved
- Positioned Wrong
- Power Loss/Surge
- Pressure/Forced
- Temperature/Cure
- Weld
- Wrong Stock Pulled
- Other

Work Order ID 97891

97891

March-01-13 10:40:59 AM

Item ID: D5957 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Saddle. 205

Start Date: 3/01/13 **Start Qty:** 4.00 *4*

Required Date: 3/15/13 **Req'd Qty:** 4.00 *4*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	**Memo**	0.00							
Hand Finishing									
140	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
140									
Powdercoat	**Memo**	0.00							
Powder Coating	START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____								
150	QC3- Inspect Part Finish	0.00							
150									
QC	**Memo**	0.00							
Quality Control									

Scrap

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data										
Equip/Tooling										
Operator										
Material										
Setup										
Other										
Process										
Supplier										
Training										
Unapproved										

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Work Order ID 97891

March-01-13 10:40:59 AM

97891

Item ID: D5957
Revision ID:
Item Name: Saddle. 205

Start Date: 3/01/13 **Start Qty:** 4.00 *4*
Required Date: 3/15/13 **Req'd Qty:** 4.00 *4*
Reference:

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location:_____	0.00							
160									
Packaging	**Memo**	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	**Memo**	0.00							
Quality Control									

MF
13-3-26

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
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- ☐ Countersink
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- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Picklist Print

March-01-13 10:41:03 AM

Work Order ID: 97891 *97891*

Parent Item: D5957 *D5957*

Parent Item Name: Saddle. 205

Start Date: 3/01/13 **Required Date:** 3/15/13

Start Qty: 4.00 **Required Qty:** 4.00

Comments: IPP Rev:E Re-Format 05-11-29 JLM
IPP Rev:F ecn826 06.12.06 ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-007		Manufactured	No			110	Each	78.0000	1	4			
D6101-007									**				
Saddle Billet													

Location	Loc Qty	Loc Code		
MAT041	77			
85432	1			
88516	4			
89349	7		4	FR 1/03/16
90563	5			
92730	30			
95910	30			
MAT042	1			
85432	1			

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
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- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data										
Equip/Tooling										
Operator										
Material										
Setup										
Other										
Process										
Supplier										
Training										
Unapproved										

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Landing Gear

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- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
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- ☐ Outside Dimensions
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- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

DART AEROSPACE LTD		Work Order:	97891
Description: Inner Aft Saddle		Part Number:	D5957
Inspection Dwg: D5957	Rev: B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.240	5.260		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		.316	.317	.317	.317		
H	1.522	1.532		1.527	1.527	1.527	1.527		
I	3.048	3.058		3.053	3.053	3.053	3.053		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.315	0.322		.316	.317	.317	.317		
L	0.495	0.505		.500	.500	.500	.500		
M	0.490	0.510		.502	.501	.500	.500		
N	1.865	1.885		1.877	1.877	1.877	1.877		
O	7.990	8.010		8.001	8.001	8.001	8.001		
P	2.240	2.260		2.252	2.253	2.253	2.253		
Q	0.308	0.313		.310	.310	.310	.310		
R	0.760	0.765		.760	.760	.760	.760		
S	0.490	0.510		.500	.500	.500	.500		
T	1.625	1.645		1.627	1.628	1.628	1.628		
U	2.000	2.020		2.002	2.003	2.003	2.003		
V	0.023	0.043		.033	.033	.033	.033		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	F.F
Date:	13/03/16

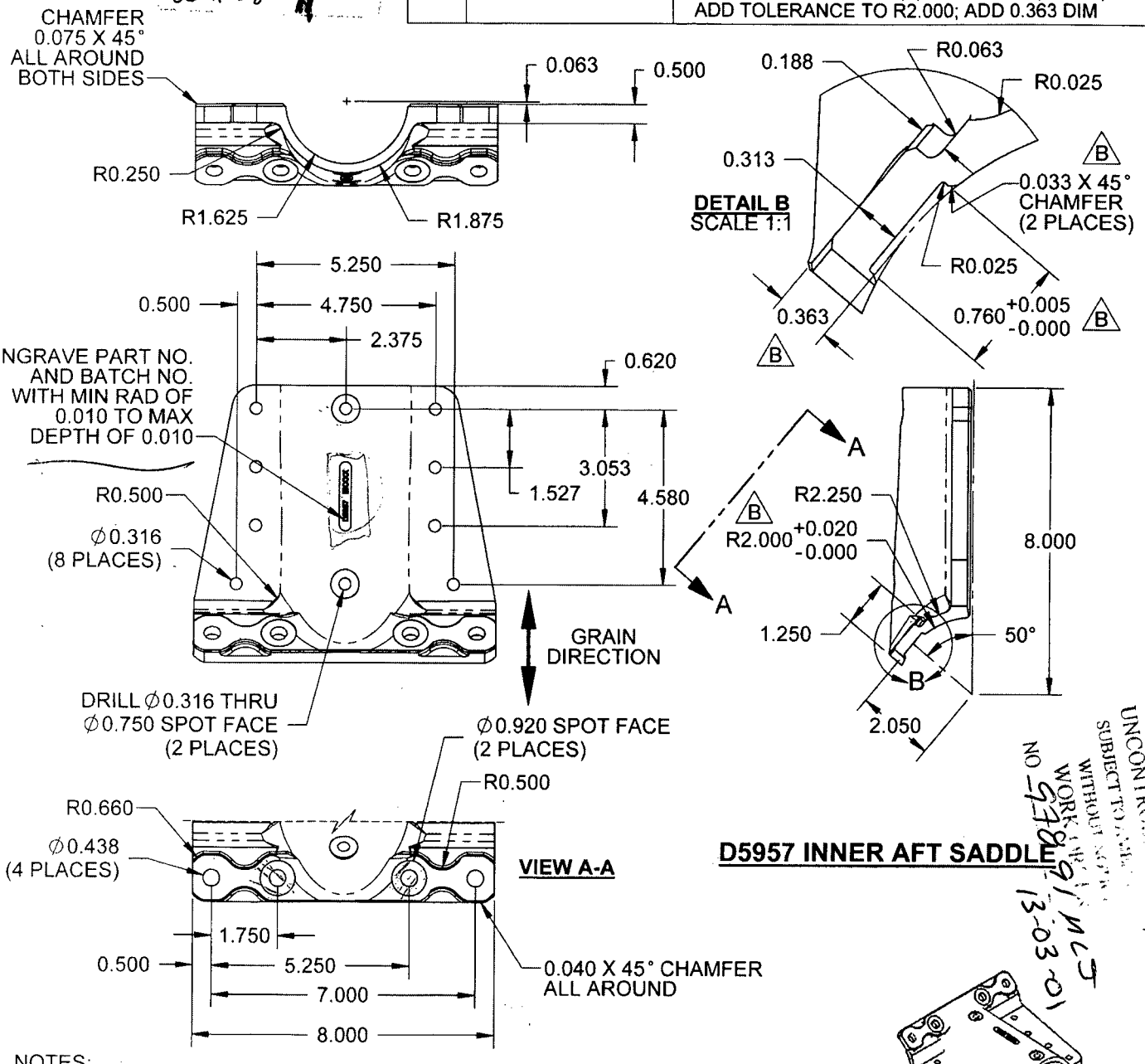
Audited by	
Date:	

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	
G	08.09.05	Dimension K revised	KJ/DD	
H	09.07.29	Dimension Q revised	KJ	

DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	CB	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. / REV.
LE		D5957 REV. B
		SHEET 1 OF 1
DATE		TITLE / SCALE
06.11.07		INNER AFT SADDLE 1:4

REV	DATE	DESCRIPTION
A	97.05.06	NEW ISSUE
B	06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; ∅0.316 WAS ∅0.313; ADD TOLERANCE TO R2.000; ADD 0.363 DIM

06.11.28



D5957 INNER AFT SADDLE

ISOMETRIC VIEW
SCALE 1:8

NOTES:
1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12
(MAKE FROM D6101-007 SADDLE BILLET, 7075)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3 B
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
5) BREAK ALL SHARP EDGES 0.010 TO 0.020

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